



Dart Aerospace Ltd.
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D2620**Job Sheet 212086**

Part No: D2620

Job Qty: 2 pcs

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/5/20

Job Tracking No:

Due Date: 9/4/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	2 pcs	9/4/20	9/4/20	0.00	0.53	Skidtubes - Bend		1/16/20-08-10
110	QC 5	2 pcs	9/4/20	9/4/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		BE 08/11/2020
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
120	Packaging 3-1 - Stock - B4B	2 pcs	9/4/20	9/4/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		



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Container No: S293143



Part: D2620

Job No: 212086

Serial No/Batch: S293143

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/10/20

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BF 08/11/2020
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
130 QC 21 - SA	2 pcs	9/4/20	0.00 0.00		

Part Op 100 - Skidtubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2-
 Descriptions: Cut Fwd end of tube as per Dwg D2620

110 - QC5- Inspect part completeness to step on W/O)

120 - Identify as per dwg & Stock Location LG002 LOCATION : LG002

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-160	Extrusion Round 3" 206	2 pcs (1 ea)	100-Skidtubes - Bend - 1	S 236156

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - Bend - 1	D2600-1-160	2	84	0

Part Specifications

Specifications could not be found.

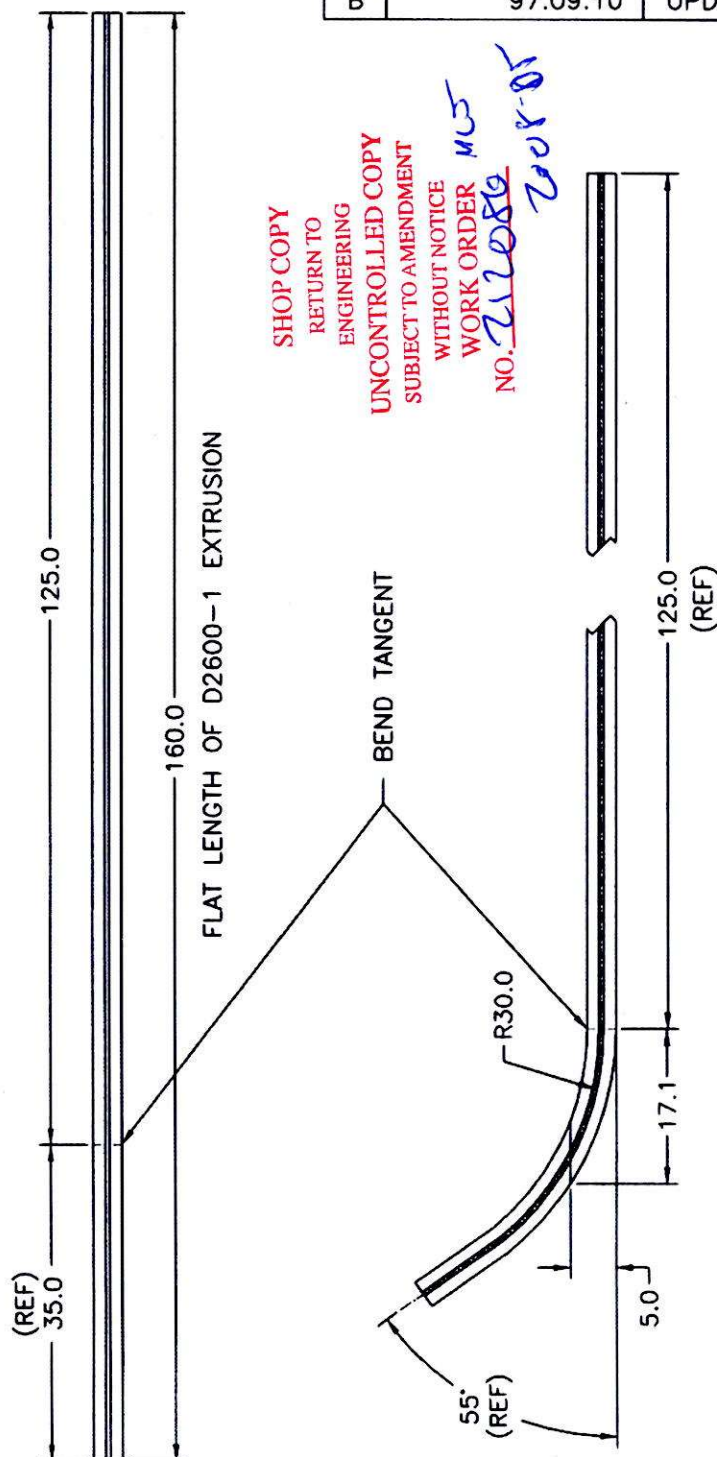
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DART

DESIGN #	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED #	APPROVED KE	DRAWING NO. D2620	REV. B SHEET 1 OF 1
DATE 99.09.10		TITLE 206 SKIDTUBE BENDING CONTROL	SCALE 1:20
A	97.11.07	NEW ISSUE	
B	97.09.10	UPDATE FOR IN-HOUSE BENDING	

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
99.09.15 DS

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					